

Shit

Work Order ID 58292 -1

May 3, 2010 10:26:56 AM



Page 1

Item ID: D2565-109

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/03/10

Start Qty: 30.00



Cust Item ID:

Required Date: 5/05/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-5-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100



Brake NC

Brake NC

NC BRAKE

Memo

Punch as per Dwg D2565 using DT 8313

0.00

0.00

*SB 10/05/13*

*(10)*

110



Small Fab

Small Fab

Small Fab

Memo

Deburr

0.00

0.00

*SB 10/05/17*

*(3)*

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*S 10/05/17*

*(+3)*





# Work Order ID 58292

May 3, 2010 10:26:56 AM



Item ID: D2565-109

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00



Cust Item ID:

Required Date: 5/05/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

1114207

Memo

START TIME:

12:45pm

1:15pm

FINISH TIME:

OVEN TEMPERATURE:

400°F

0.00

79d 10/05/17

3 4

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3 BL 10-5-17.

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

270

0.00

10/05/17 (3)





# Work Order ID 58292

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Item ID: D2565-109

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/03/10 Start Qty: 10.00



Cust Item ID:

Required Date: 5/05/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17 JF  
M 10-5-17  
③

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Checklist Print

May 3, 2010 10:26:56 AM

Page 1

Work Order ID: 58292

Parent Item: D2565-109

Parent Item Name: Strut

Comments: IPP: F 02.04.16 Added dwg Rev.C1 NG

Start Date: 5/03/10

Required Date: 5/05/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	303.4562	1.0258			



304 RD Tube .750 x .049W



Location	Loc Qty	Loc Code
MAT	275.5927	
108498	0	
114482	275.5927	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

13

SB 10/05/13

(10)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_





Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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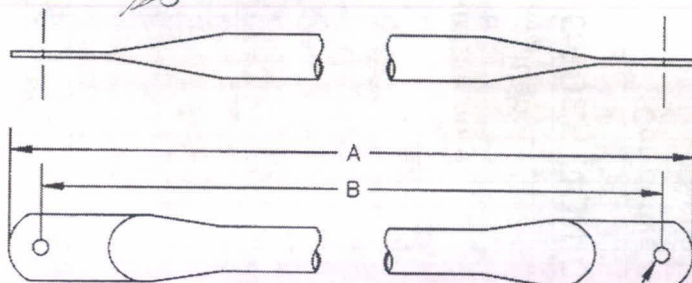




DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05			TITLE STRUT SCALE 1:3		
A	96.05.03		NEW ISSUE		
B	97.03.15		CORRECT D2565-111 DIM. A		
C	98.10.05		UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05		ADD -3XX PARTS; ADD FINISH		
E	04.05.05		ADD D2565-401-411; RMV ANGLE D		

**RELEASED**  
04.05.05

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58292  
2810-503



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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